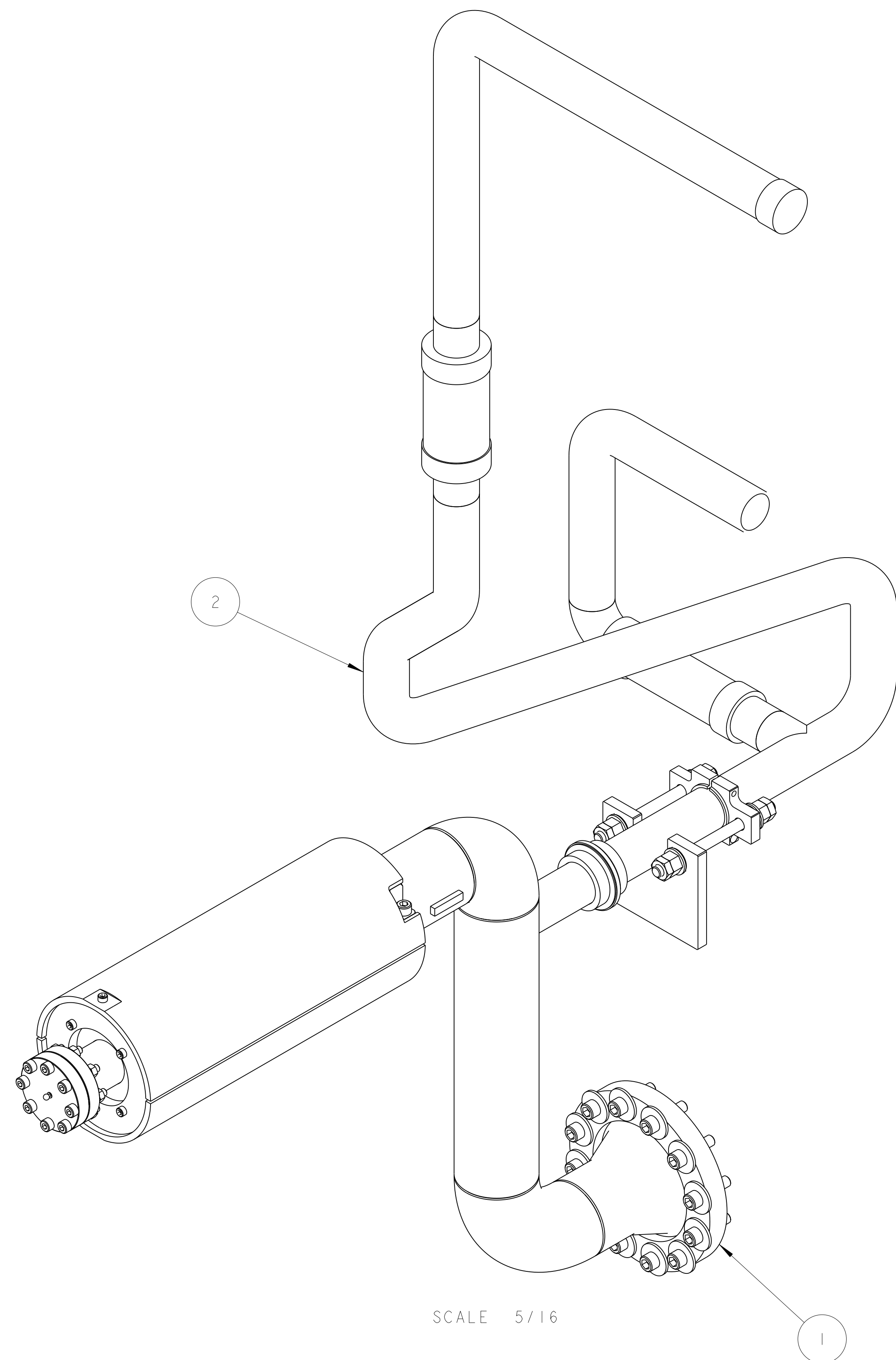
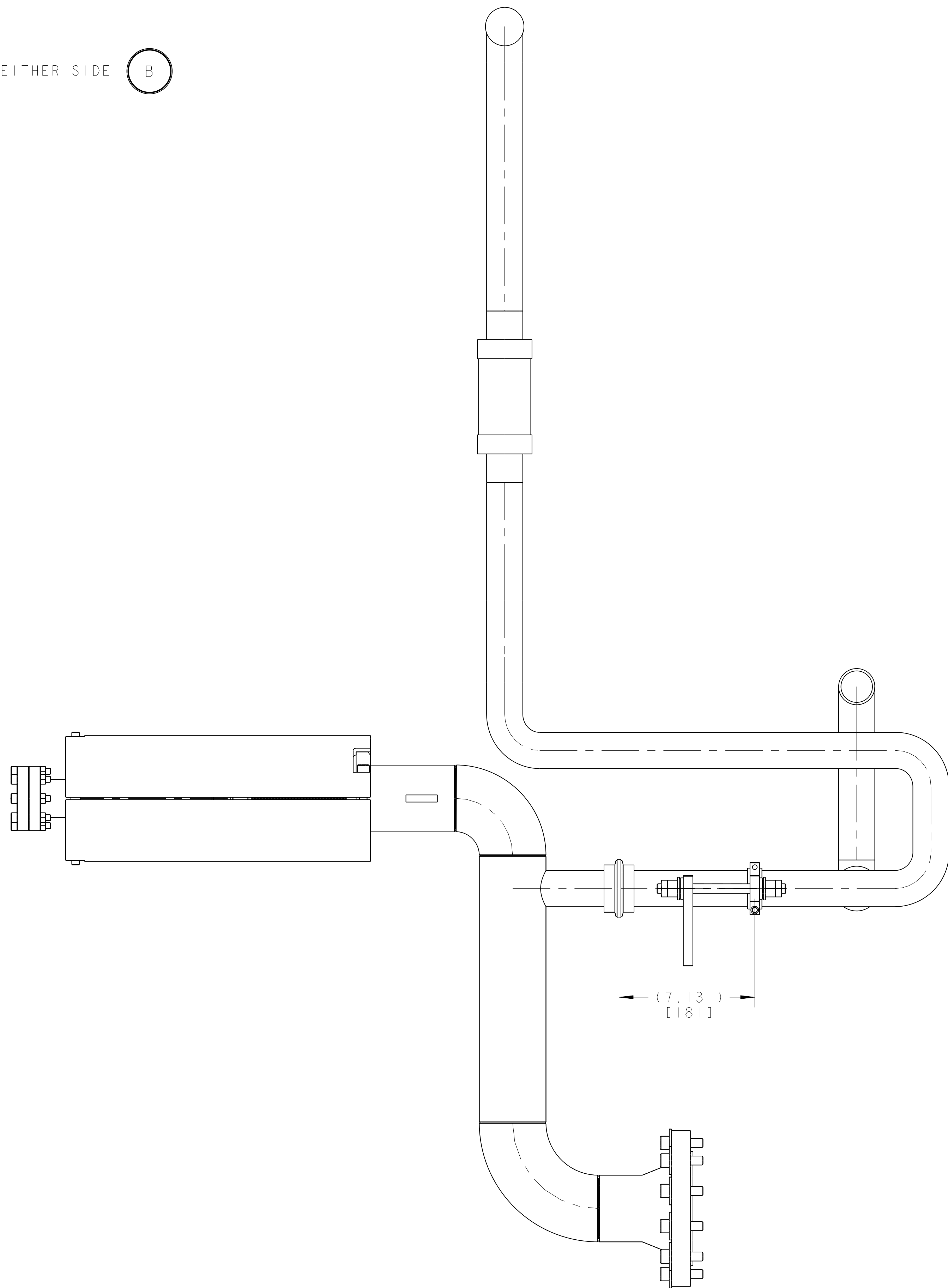



1. THIS IS A CRYGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063$ ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.



SCALE 5/16

### THIRD ANGLE PROJECTION

				UNLESS OTHERWISE SPECIFIED				ITEM		PART NO.		RECD		DESCRIPTION				MATERIAL	
				TOLERANCES				SHOP ORDERS		SERIAL NO.		DATE		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY					
				X.X ± 0.1 FRACTION ± 1/64				REC'D NO.		NO.		DATE		UNIVERSITY OF CALIFORNIA BERKELEY					
				X.XX ± 0.03 ANGLES ± 1.00°				NO.		NO.		DATE							
				X.XXX ± 0.010 FINISH 125µIN				TO		RECD		DATE							
				DO NOT SCALE				SURFACES TREATMENT											
				THREADS ARE CLASS 2				TOLERANCE TAG											
				CORNER RADIUS OF ALL SCREW THREADS 1/16"				METHOD											
								PROPERTIES N/A											
								NUMBER N/A											
								PROFILES N/A											
								NAME N/A											
								BY											
								DATE 13-May-02											
								DATE 04-Oct-02											
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